



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3910-7

Job Sheet 180277



Part No: D3910-7

Job Qty: 20 ea

Part Name: Crosstube Lug



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/4/18

Job Tracking No:

Due Date: 8/22/18

Created By: Chantal Lavoie

Type: Stock

Description:

Note: D3910 REV.E IPP REV:A 14.05.21 NEW ISSUE DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Purchasing	20 pcs		8/22/18	0.00	0.00	Purchasing		AUG 15 2018
120	Packaging	20 pcs		8/22/18	0.00	0.00	Packaging2		AUG 15 2018
130	QC	20 pcs		8/22/18	0.00	0.00	QC6		38 4/18/2018
140	HandFinish	20 pcs		8/22/18	0.00	0.34	HandFinish1		
150	QC	20 pcs		8/22/18	0.00	0.00	QC7-3		
160	Powdercoat	20 pcs		8/22/18	0.00	0.18	Powdercoat1		
170	QC	20 pcs		8/22/18	0.00	0.00	QC3		
180	Packaging	20 pcs		8/22/18	0.00	0.00	Packaging3-2		AUG 23 2018
190	QC21-SA	20 Ea		8/22/18	0.00	0.00	QC21		AUG 24 2018

Part Op 110 - ISSUE PO TO METEC, NOTE ALODINE AND PAINT AS PER QSI 005
 Descriptions: 120 - Ensure C of C is attach
 160 - START TIME: _____ OVEN TEMPERATURE: _____ FINISH TIME: _____
 JUL 04 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2423	Lug Extrusion	2.4000 ft (.12 ea)	110-Purchasing	5102487
D3910-7P	Crosstube Lug	20 pcs (1 ea)	110-Purchasing	5102493

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Purchasing	D2423	2	53	0
	D3910-7P	20	5	0



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Part Specifications

could not be found.

Plex 7/4/18 8:38 AM dart.lavoie.chantal

Container No: S102494



Part: D3910-7

Job No: 180277

Serial No/Batch: S102494

Revision: E

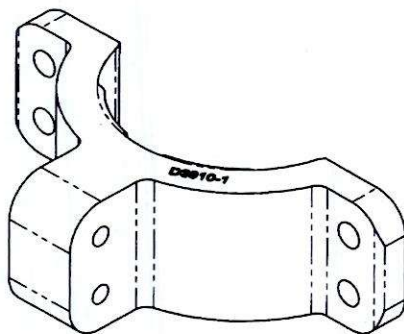
Inspector:

Exp Date:

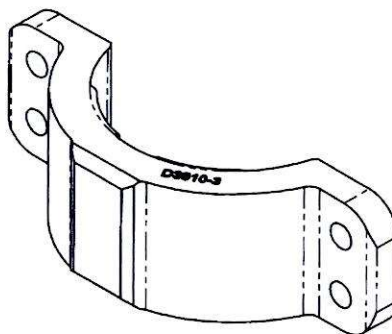
Instructions: Various STC's

Date: 08/15/18

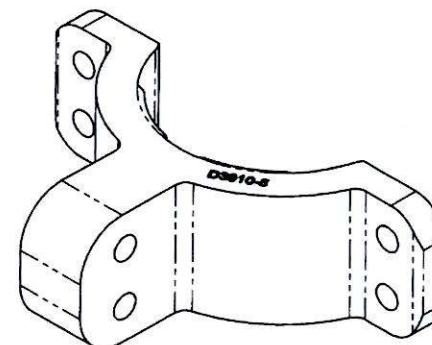
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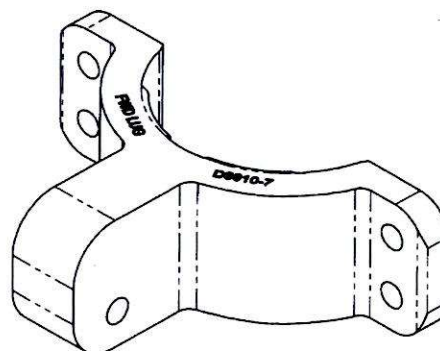
D3910-1 X-TUBE LUG



D3910-3 X-TUBE LUG



D3910-5 X-TUBE LUG



D3910-7 X-TUBE LUG

NOTES:

- 1) MATERIAL: MAKE FROM D2423 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER TO A DEPTH OF 0.010 $\pm$ 0.005 IN THIS LOCATION WITH A TOOL TIP RADIUS OF 0.015 $\pm$ 0.005
- 7) WEIGHT: -1: 0.32 lbs
-3: 0.25 lbs
-5: 0.36 lbs
-7: 0.37 lbs
- 8) IDENTIFICATION: ENGRAVE "FWD LUG" TO A DEPTH OF 0.010 $\pm$ 0.005 IN THIS LOCATION WITH A TOOL TIP RADIUS OF 0.015 $\pm$ 0.005

RELEASED

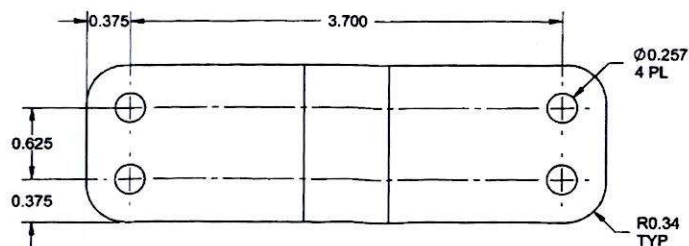
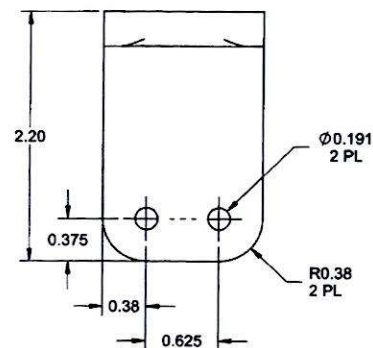
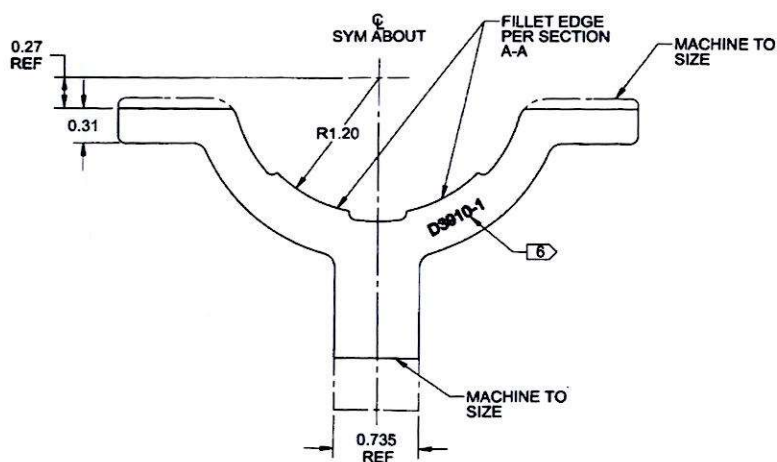
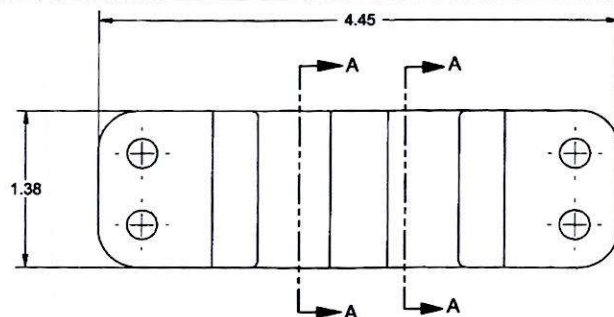
2014 JUN 05
ECN 14-572

E	ADD -7 PER NCR14-3871	AJS	14.05.16
D	CHANGED FASTENER HOLES IN -5 FOR 1/4" HARDWARE. REASON: EASE OF INSTALLATION.	AJS	13.08.14
C	ADD -5.	AJS	13.08.08
B	Ø 0.287 HOLES: 4 PL WAS 2 PL (A3-2) & (A3-3); R0.34 FILLET WAS R0.50 (A3-2) & (A3-3). REASON: SEE TR-0350-807-2	JPH	10.03.16
A	NEW ISSUE	JPH	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. E
MFG. APPR.	<i>[Signature]</i>	D3910	SHEET 1 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	X-TUBE LUG (350)	NTS
DATE	14.05.16	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. USE IS LIMITED TO THE EXPRESS COORDINATION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR DISCLOSED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



ROUND EDGE
R0.06 MIN - R0.10 MAX
2 PL

SECTION A-A



D3910-1 X-TUBE LUG

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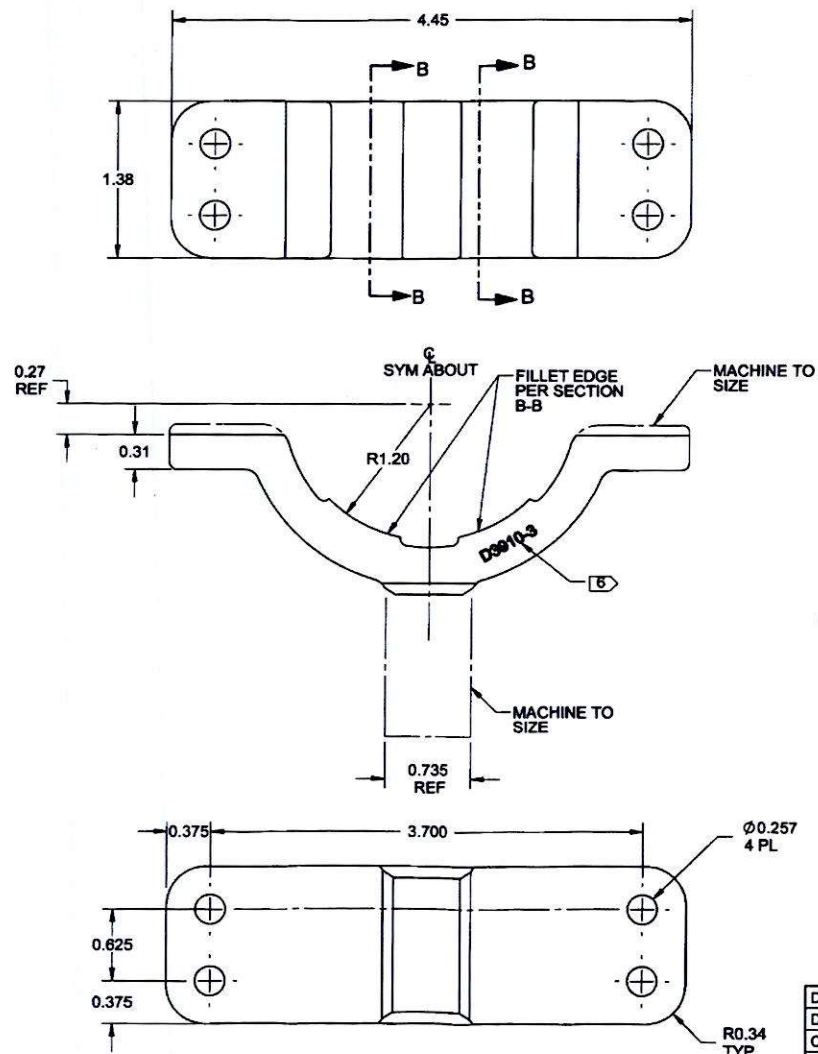
2014 JUN 05

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CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. E
MFG. APPR.	<i>[Signature]</i>	D3910	SHEET 2 OF 6
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	X-TUBE LUG (350)	NTS
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SECTION B-B



ROUND EDGE
R0.06 MIN - 0.10 MAX
2 PL



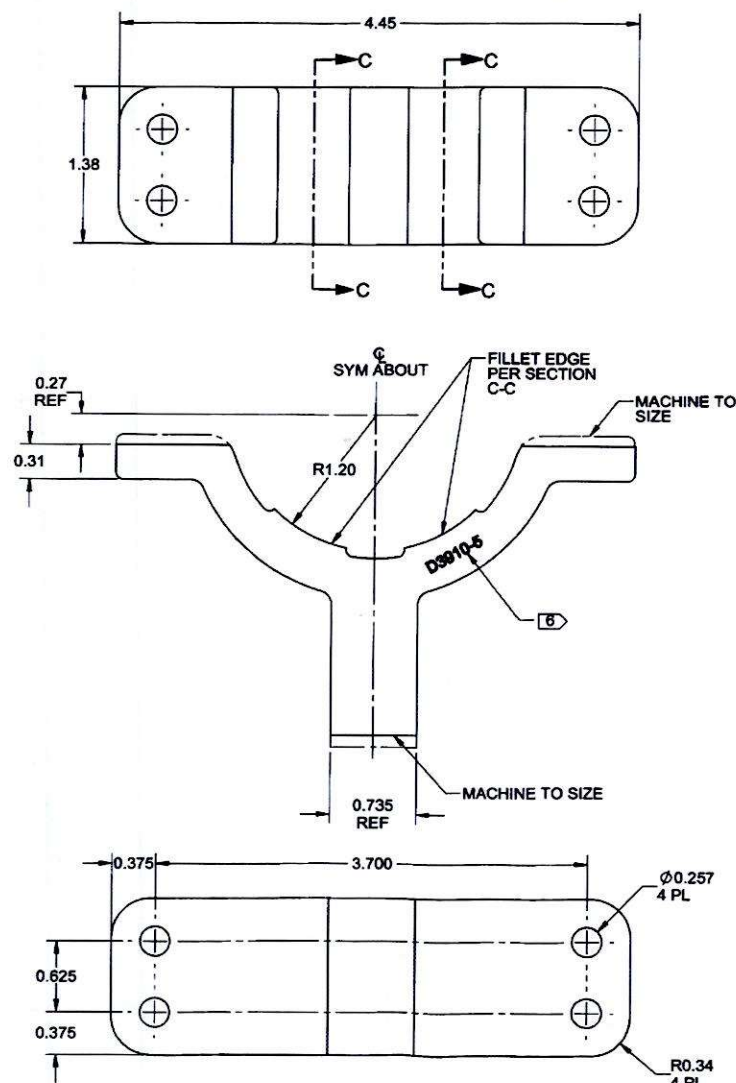
D3910-3 X-TUBE LUG

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2014 JUN 05

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	J	DRAWING NO.	REV.
MFG. APPR.	21	D3910	SHEET 3 OF 5
APPROVED	14	TITLE	SCALE
DE APPR.	14	X-TUBE LUG (350)	NT
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—ROUND EDGE
R0.06 MIN - 0.10 MAX
2 PL



Technical drawing of a 2x2 plate. The drawing shows a rectangular plate with a total width of 2.55 and a total height of 0.54. The plate has two circular holes, each with a diameter of $\varnothing 0.261$. The distance between the centers of the holes is 0.625. The holes are located 0.38 from the left and right edges. The bottom corners of the plate are rounded with a radius of R0.50. The plate is labeled "2 PL" (2 plates).

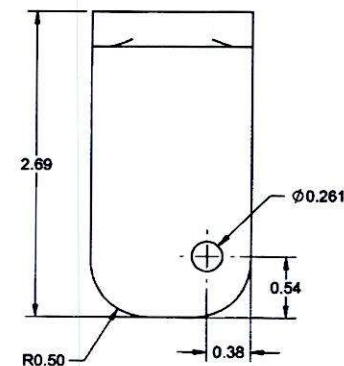
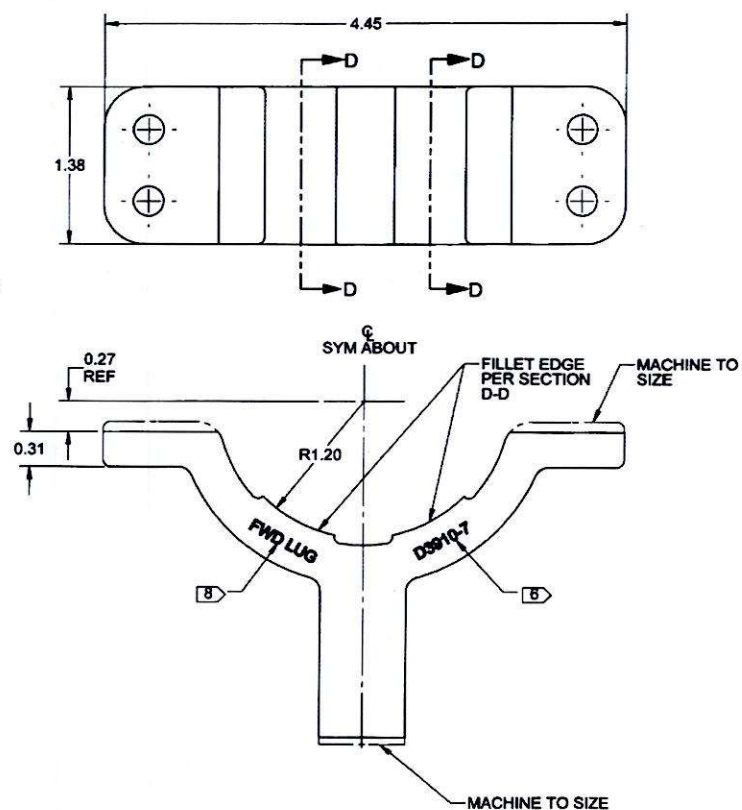
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2014 JUN 05 *ap*

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3910 TITLE X-TUBE LUG (350) COPYRIGHT © 2016 BY DART AEROSPACE LTD THIS DOCUMENT IS PROPERTY OF DART AEROSPACE LTD. NO REPRODUCTION OR TRANSMISSION OF ANY KIND IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSONS WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>		REV.
MFG. APPR.	<i>[Signature]</i>		SHEET 4 OF
APPROVED	<i>[Signature]</i>		SCALE
DE APPR.	<i>[Signature]</i>		NT
DATE 14.05.16			

SECTION D-D



ROUND EDGE
R0.06 MIN - 0.10 MAX
2 PL



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2014 JUN 05

D3910-7 X-TUBE LUG

DESIGN	AJS	DART AEROSPACE LTD	
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MFG. APPR.		D3910	SHEET 5 OF 5
APPROVED		TITLE	SCALE
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Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

PO040391

Supplier: MEM001-VC
Metec Metal Technology Inc.
20 Terry Fox Drive PO Box 781
Vankleek Hill
ON
K0B 1R0 Canada
Phone: 613 678 3957
Fax: 613 678 3956

PO No: PO040391

PO Date: 7/4/18

Due Date: 8/20/18

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Baker, Diane
Phone: dbaker@dartaero.com

Attention: Walz, Shigi

Via: Ground

Pymt Terms: Net 60

Freight Terms:

Special Comments:

Revision

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Items

Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	180263	D2230-1P			Lug As Per Dwg D2230 Rev. G Alodine and Paint as per QSI 005	Firmed	-	8/20/18	100 pcs	0 pcs	100 pcs	\$17.40/pcs	\$1,740.00
									62 X	AUG 15 2018			
2	180266	D2230-3P			Lug As Per Dwg D2230 Rev. G Alodine and Paint as per QSI005	Firmed	-	8/20/18	100 pcs	0 pcs	100 pcs	\$14.90/pcs	\$1,490.00
3	180269	D2731-3P			Lug As Per Dwg D2731 Rev.C	Firmed	-	8/20/18	30 pcs	0 pcs	30 pcs	\$16.20/pcs	\$486.00
									32 X	AUG 15 2018			
4	180272	D3394-1P			Lug As Per Dwg D3394 Rev. B	Firmed	-	8/20/18	30 pcs	0 pcs	30 pcs	\$20.45/pcs	\$613.50
									30 X	AUG 15 2018			
5	180273	D3910-1P			Crosstube Lug As Per Dwg D3910 Rev. E Alodine and Paint as pe QSI 005	Firmed	-	8/20/18	20 pcs	0 pcs	20 pcs	\$17.40/pcs	\$348.00
									20 X	AUG 15 2018			
6	180275	D3910-3P			Crosstube Lug As Per Dwg D3910 Rev. E Alodine and Paint as Per QSI 005	Firmed	-	8/20/18	20 pcs	0 pcs	20 pcs	\$17.40/pcs	\$348.00
7	180277	D3910-7P			Crosstube Lug As Per Dwg. D3910 Rev. E Alodine and Paint as Per QSI 005	Firmed	-	8/20/18	20 pcs	0 pcs	20 pcs	\$17.40/pcs	\$348.00
									20 X	AUG 15 2018			

DAS
61
9-89

DAS
88
-89

Items													
Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
Grand Total:													\$5,373.50
Order Notes													
Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation. Procurement Quality Clauses A005 RIGHT OF ENTRY A007 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION MAINTAINED BY SUPPLIER) A012 CHEMICAL AND PHYSICAL TEST REPORTS A016 PERSONNEL QUALIFICATION A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE) A026 CERTIFICATION OF MATERIAL CONFORMANCE A041 QUALITY MANAGEMENT SYSTEM A042 DART NOTIFICATION BY SUPPLIER A043 RETENTION OF QUALITY DOCUMENT A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM A049 SUPPLIER AWARENESS													

Plex 7/10/18 9:11 AM dart.Lussier.Patrick

**METAL TECHNOLOGY INC.**

20 Terry Fox Drive
Vankleek Hill, Ontario K0B 1R0 , Canada
Tel: (613) 678-3957
Fax: (613) 678-3956

Delivery Slip No.: 22853

Date: Aug 15, 2018

Page: 1

Sold to: Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7	Ship to: Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7
Order No.: PO040391 NC	Sold By: Walz, Christian D.
Shipped By: pick up	Ship Date: Aug 15, 2018

Description	Bin Loc	Unit	Quantity ordered	Quantity shipped	Quantity on B/O
D2230-1 Mounting Lug 62 in stock alodined and painted as per QSI 005		Each	100	62 ✓	38
D2230-3 Mounting Lug no stock alodined and painted as per QSI 005		Each	100		100
D2731-3 Mounting Lug in stock alodined and painted as per QSI 005		Each	30	32 ✓	
D3394-1 Lug in stock alodined and painted as per QSI 005		Each	30	30 ✓	
D3910-1 Crosstube Lug in stock alodined and painted as per QSI 005		Each	20	20 ✓	
D3910-3 Crosstube Lug no stock alodined and painted as per QSI 005		Each	20		20
D3910-7 Crosstube Lug in stock alodined and painted as per QSI 005		Each	20	20 ✓	
The delivered goods must be inspected upon receipt to confirm compliance. Should there be discrepancies please notify METEC within 30 days of delivery. The goods are otherwise deemed accepted.					
Received by _____			Thank you for your order!		

DAS
61
9-89

DAS
38
9-89



20 Terry Fox Drive, Vankleek Hill, Ontario K0B 1R0
Tel. (613) 678-3957 & (613) 678-2782 Fax (613) 678-3956 metec@metec.ca

CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

Quantity	Part Number	Part Name	Material Batch #	Paint Batch #	P.O. Number
30	D3394-1	Lug	115529	21778	40391
20	D3910-7	Crosstube Lug	131451	20366	40391
20	D3910-1	Crosstube Lug	160522	22006	40391
32	D2731-3	Lug	127892	20082	40391
62	D2230-1	Mounting Lug	160522	21965	40391

MATERIAL: supplied by DART

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

Heather Nixon

Vankleek Hill, August 15, 2018